



Dart Aerospace Ltd.
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D3243-041
Job Sheet 206530



Part No: D3243-041

Job Qty: 6 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/3/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 2/17/20

Description:

Type: SOLD *sta*

Note: DWG REV A IPP Rev:A New Issue 05-11-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	6			0.17	0.66	Waterjet - Flow		<i>on 20/02/10</i>
120	QC 2	6			0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>on 20/02/10</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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130 QC 8	6 pcs	0.00 0.00	QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	DAS FEB 12 2020 40 9-89
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
150 Small Fab - Brake NC - B4B	6 pcs	0.25 0.59	Small Fab - Brake - 1 - B4B	DAS 30 FEB 18 2020
			Small Fab - Brake - 2 - B4B	9-89
			Small Fab - Brake - 3 - B4B	
160 QC 5	6 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	DAS FEB 19 2020 40 9-89
			QC 5 - 61	
			QC 5 - 81	
170 Handfinish - 1-1 Chemical- B4B	6 pcs	0.00 0.24	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	

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			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	M 20.2.20
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
180 Small Fab - 2 - B4B	6 pcs	0.00 0.25	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	FEB 20 2020
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
190 QC 5	6 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	FEB 20 2020 40
			QC 5 - 61	DAS 8-89
			QC 5 - 81	
200 Powdercoat - 4 Black Sand - B4B	6 pcs	0.00 0.19	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	FEB 20.02.20
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
210 QC 3	6 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	

			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	FFR 2 4 2020
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
220	Packaging 3-1 - Stock - B4B	6 pcs	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
				Packaging 3 - 37 - B4B
230	QC 21 - SA	6 pcs	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 53

Part Op 110 - 1-Cut as per Dwg

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

150 - (Form as per dwg) Form as per Dwg D3243

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Chemical Conversion Coat per QSI005 4.1)

180 - (Small Fab) Install Inserts as per Dwg D3343

190 - (QC5- Inspect part completeness to step on W/O)

5156440 200 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *****Mask Holes***** START: 8:05 TEMP: 320° FINISH

210 - (QC3- Inspect Part Finish)

220 - (Identify as per dwg & Stock Location: _____)

230 - (QC21- Final Inspection - Work Order Release)

8:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	3.2994 sf (.5499 ea)	110-Waterjet - Flow - 1	5227116
FE-032-EF	Inserts Alt: FE-032-MD	24 Ea (4 ea)	180-Small Fab - 2 - B4B	5255560

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6S.063	3	248	0
180-Small Fab - 2 - B4B	FE-032-EF	24	37	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Engineering ☐ Machining ☐ Water Jet ☐ Large Fab ☐ Supplier ☐ Quality ☐	MRB (QS1042)																																							
Date : _____	Sequence #: _____	QTY Affected : _____																																								
Description Work Order Deviation		Disposition																																								
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Operator ☐</td> <td style="width:33%;">Pressure/Forced ☐</td> <td style="width:33%;">Contamination ☐</td> </tr> <tr> <td>Manufacturing Process ☐</td> <td>Bending ☐</td> <td>Misaligned/off center ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Crushing ☐</td> <td>BOM/Route ☐</td> </tr> <tr> <td>Handling/Preservation ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> </tr> <tr> <td>Material ☐</td> <td>Crimp/kink/Ripple/Wave/Twist ☐</td> <td>Incomplete/Unclear Instructions ☐</td> </tr> <tr> <td>Product Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> </tr> <tr> <td>Process Improvement ☐</td> <td>Mislabeled ☐</td> <td>Fit/Function ☐</td> </tr> <tr> <td>Human Factors ☐</td> <td colspan="2">Other/Details: _____</td> </tr> </table>		Operator ☐	Pressure/Forced ☐	Contamination ☐	Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Material ☐	Crimp/kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Human Factors ☐	Other/Details: _____		FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Power Loss/Surge ☐</td> <td style="width:33%;">Positioned Wrong ☐</td> <td style="width:33%;">Outside Tolerance ☐</td> </tr> <tr> <td>Folio/Program ☐</td> <td>Drawing ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Grain Direction ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Weld ☐</td> <td>Out of Sequence ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Off-set/Set-up ☐</td> <td colspan="2"></td> </tr> </table>		Power Loss/Surge ☐	Positioned Wrong ☐	Outside Tolerance ☐	Folio/Program ☐	Drawing ☐	Finish ☐	Grain Direction ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Weld ☐	Out of Sequence ☐	Misread ☐	Off-set/Set-up ☐		
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QC / QA Coordinator _____																																										